

Work Order ID 57512

April 8, 2010 7:17:58 AM



Page 1

Item ID: D3537-3

Accept

Revision ID:

Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00

Required Date: 4/16/10 Req'd Qty: 20.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-

Deburr if necessary

304.063

10-4-8

23

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-4-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/04/09

counted

723

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr if necessary ☐ Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 ☐ Form Joggle as per Dwg D3537 on brake using Jig DT8158

0.00

0.00

SP 10/04/12 (23)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D3429

0.00

0.00

S 10/04/12

center (23)

150



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch ☐ A/R 2059B Hardcoat
☐ Weld hardcoat as per Dwg D3437

0.00

0.00

PL 10-4-15 (23)

11/4/373

W/O:		WORK ORDER CHANGES					
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Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:00 AM ☐ OVEN TEMPERATURE:
9:30 AM ☐ FINISH TIME: 3:00 PM

8/10/04/19

8/10/04/19

7/10/04/20

count
23

23

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: FP-17

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-4-20

23

0

10/04/20

MF 10-4-20

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Picklist Print

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Page 1

Work Order ID: 57512



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	34.2000	3.1368	3.7		



304/316 Sheet .063

HR10-4-8

Warehouse

Location

Main Warehouse

MAT20

113295

Loc Qty

34.2

34.2

Loc Code

113298

23

Dart Aerospace Ltd

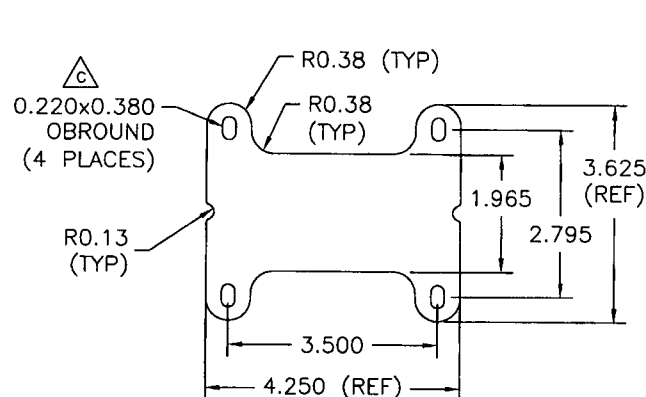
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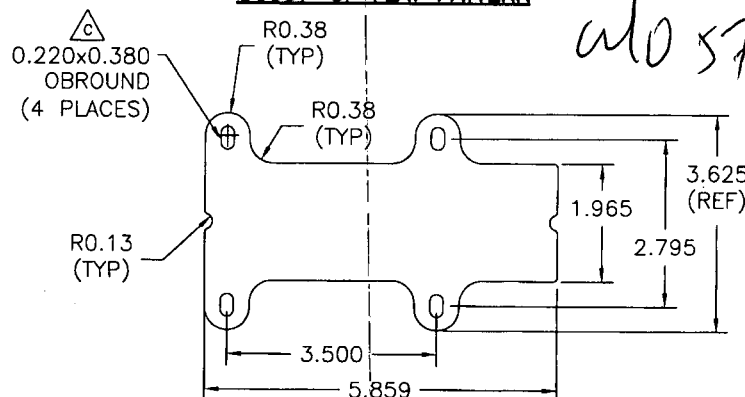
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D3537-1F FLAT PATTERN

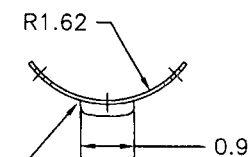


D3537-3F FLAT PATTERN



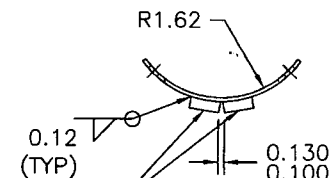
40 57512

SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B

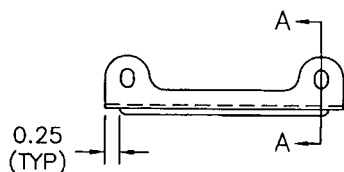


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07.05.08 PM
P. 27 ECLN
952

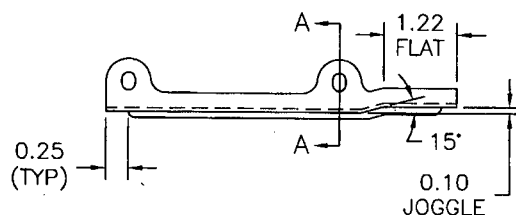
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



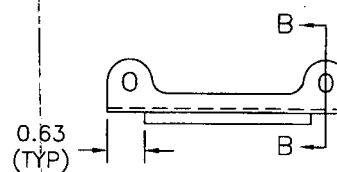
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



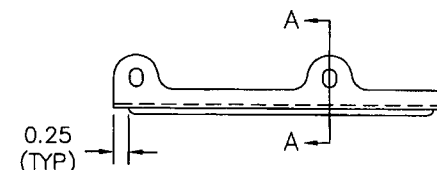
D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

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